99771

Page 1

April-11-13 3:30:04 PM Item ID: D2278 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg **Start Date:** 4/11/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 4/11/13 Req'd Qty: 4.00 **Customer:** Reference: Run **Approvals:** Process Plan: MLJ Date: 13-04-16 Tooling: Date: OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Reject Set Up/ Tool # Plan Reject Accept **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D2278 Rev F 100 0.00 FLOW WATER JET *100* TM13-07-02 Waterjet 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D2278 Dwg Rev: F Prog Rev: F 6061.080 Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check *120* Memo Quality Control

										DQ	A: Dat	te:	
NCR:	Yes / No				WORK ORDER NON-C	O	NFORI	MANCE / UP	PDATE				
										QA Close	d: Dat	te:	
Mark Ord					DISPOSITION				AGAINST DI	EPARTMEN	IT/PROCESS		
Work Ord	er				Rework	1	ŧ	Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	No				Scrap		į .	Machining	Small Fab	- P	rod. Eng. Coor.	\Box	Quality
t art i	···				Use-as-is		•	noforming	Finishing		tore/Packaging		Other
NCR I	No.				Work Order Update	1		Large Fab	Composite	1	Supplier		
						•							
Root				Descri	ption of work order update		Initial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	n	QC Inspector
Doc/Data												İ	
Equip/Tooling						ļ							
Operator													
Material													
Setup													
Other	<u></u>												
Process													
Supplier													
Training													
Unapproved				İ		<u> </u>				<u> </u>			
					······································	AUI	LT CATE	GORY					
Landi	ng Gear			<u> </u>	General	_	1 ₀ .		Г	7			ressure/Forced
	Bending				Bend	<u> </u>	Grain		<u> </u>	Ovalized			
		Not Conce	ntric to	o/s	BOM/Route	-	Hardwa			⊣ `	ler tolerance	\vdash	emperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	-	on Incomplete	,, <u> </u>	Part Incor		\vdash	Veld
	⊢	/Crimped		<u> </u>	Burrs	<u> </u>	4	ions Incomplete,	/Unclear	Part Lost/	_	L □ ^v	Vrong Stock Pulled
	Cuffs				Contamination	<u></u>	Mainte		<u> </u>	Part Move			
	Heat Tre	eat			Countersink	<u> </u>	Mislabe	led	_	Positione	_		
	Inspecti	on Strin in	Tube	1	Cut Too Short	1	Misread	1	1	Power Los	ss/Surge	1 10	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

99771

Work Order ID 99771

Packaging

April-11-13 3:30:04 PM Item ID: D2278 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg Start Date: 4/11/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 4/11/13 **Req'd Qty:** 4.00 **Customer:** Reference: Run **Process Plan: Approvals:** Date: **Tooling:** Date: QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Qty Number Stamp Code 130 Chemical Conversion Coat per QSI005 4.1 0.00 *130* HandFinish 0.00 Memo Hand Finishing 140 Inspect Part Finish 0.00 *1/10* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 150 0.00 *150* Packaging 0.00 Memo

			DQA:	Date:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		
	•		OA Closed:	Date:

											QA Closed.	Date	•
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part f	- No					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ini	itial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling							İ						
Operator													
Material													
Setup	Ш												
Other											ļ		
Process	Ш												
Supplier													
Training	Ш		ļ										
Unapproved			<u> </u>	Ĺ			<u> </u>						
							AULT	CATE	GORY				
Landi						General				_	1	_	¬
		Bending				Bend	—	Grain		ļ	Ovalized	_	Pressure/Forced
	-	Centre No	ot Concer	ntric to	o/s	BOM/Route	\vdash	lardwa			Over/Under	_	Temperature/Cure
	\vdash	Cracks			_	Broken/Damaged	\vdash		on Incomplete		Part Incorred	<u> </u>	Weld
	-	Crushed/0	Crimped.		<u> </u>	Burrs			ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	ш	Cuffs			<u> </u>	Contamination	\longrightarrow		nance		Part Moved	.,	
	-	Heat Trea			<u> </u>	Countersink		/lislabe		}	Positioned V		Other
		Inspection		Tube	<u> </u>	Cut Too Short	-	/lisreac	1	<u> </u>	Power Loss/	Surge [Other
	$\boldsymbol{\vdash}$	Ripples in			ļ	Drill Holes		Offset	5 - 114 A1				
	-	Torque W		xtrusio	ⁿ _	Drawing	\vdash		Calibration				
	-	Turning S				Finish	—		equence			·	
		Wave/Tw	ist in Tub	e e	1	Folio		Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

April-11-13 3:30:04 PM Item ID: D2278 Accept *N900040100* Setup Start **Revision ID:** Item Name: Step Leg Start Qty: 4.00 4/11/13 **Start Date: Cust Item ID:** Required Date: 4/11/13 **Req'd Qty:** 4.00 **Customer:** Reference: Run **Process Plan: Tooling:** Approvals: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Reject Accept Work Center ID Description **Run Hours** Code Qty Qty Number Stamp QC21- Final Inspection - Work Order Release 160 0.00 *160*

0.00

Memo

mf 9-04

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

	·								QA Closed:	Date	:
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is	Thor	Skid-tube Machining moforming	Crosstube Small Fab Finishing	ł	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	0				Work Order Update	_ Inter	Large Fab	Composite	Nec/sto	Supplier	- Other
Root				Descr	iption of work order update	Initial	Α	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	g Des	cription	Date	Verification	QC inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		·									
опаррточец		l			F	AULT CAT	EGORY		L		
Landin	g Gear				General						
	Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing	Instruction Maint Mislab Misrea Offset	tion Incomplete ctions Incomplete enance deled	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
F	Turning So	•			Finish Folio	—	Sequence e Dimensions				
l l	Wave/Tw	ist in Tüb	Je		ILOHO	1 Joursia	e Dimensions				

Picklist Print

April-11-13 3:30:08 PM

Work Order ID: 99771

D2278

99771 *D2278*

Parent Item Name: Step Leg

Start Date: 4/11/13

Required Date: 4/11/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

IPP Rev:A IPP Rev:B

New Issue

05-11-07 JLM

Now 6061-T6 06-06-23 JLM

IPP Rev C

New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	254.5600	0.9815	_ 4_1326 32			
M6061T6	S 080								**	5.0		J	MB-0702

6061-T6 .080 Sheet

Location	Loc Qty	Loc Code	
MAT021	254.560032		
117285	0.497264		
124786	254.062768		

125812

125812

DQA: ____Date: ______Date: ______Date: ______DATE

NCR: Ye	es / No				WORK ORDER NON-	CON	IFORI	MANCE / UPDATE			
									QA Closed:	Date:	
Work Order	r.				DISPOSITION			AGAINS	T DEPARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is			Skid-tube Crosstube Machining Small Fall noforming Finishing	Pro	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR No	o				Work Order Update]	Hern	Large Fab Composite	- ├──	Supplier	
Root				Descri	ption of work order update	lr	nitial	Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Description	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator	_					-			ĺ		
Material											
Setup	_										
Other											
Process	_			•							
Supplier	_		.								
Training											
Unapproved											
			· · · · · · · · · · · · · · · · · · ·		F	AUL	CATE	GORY			
Landing	g Gear				General						-

			.,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
ndir	ng Gear	General			
	Bending	Bend	Grain	Ovalized Pressure/Forced)
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance Temperature/Cu	ıre
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect Weld	
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing Wrong Stock Pul	ıled
	Cuffs	Contamination	Maintenance	Part Moved	
Ī	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
Ī	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other	
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
	Wave/Twist in Tube	Folio	Outside Dimensions		

DART AEROSPACE LTD	Work Order:	99771
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

			L			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	0.351"	_	· · · · · · · · · · · · · · · · · · ·	V	Jamos
0.354	+/-0.010	0.353"	_		1/	
16.46	+/-0.030	16.46			7	Tkm 06
Ø0.128	+0.005/-0.000	0.139"	_		V	JRMOG
R0.354	+/-0.030	0.354	-		RG	
2.00	+/-0.030	2.005"			V	
4.74	+/-0.030	4.74"	_		v ·	
8.46	+/-0.030	8.467	-		ν	Palito
0.213	+/-0.010	6.215"	_		V	Produtos
0.750	+/-0.010	0,753			V	
0.080 thick	+/-0.010	0.073	-		V	
		0,077				
					. €.	
			-			
<u> </u>						
					· .	
					<u> </u>	
·			ı		ı	i

Measured by: Jm	Audited by:	OAS	Prototype Approval:	N/A
Date: 13-07-02	Date:	3-50/13/0/02	Date:	N/A

Rev	Date	Change	+3-	Revised by	Approved
Α	04.10.12	New Issue P/O D2582		KJ/JLM	7.00104
В.	06.03.08	Dwg Rev. changed		KJ/JLM	
С	06.06.23	Dwg Rev. changed		KJ/JLM	
D	08.02.28	Dimensions updated per Dwg Rev F		KJ/DD	1/2

	4
	×



